

5/28/20

(4)

DART AEROSPACE LTD	Work Order:	22409
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	4 8

Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Note: K10017 Kits to be made in multiples of 4. (1) K10017 Kit consists of (2) D3175-041 and (2) D3178-041.	SP	05.02.14	8
2	MV	Cut blanks: 3.00" x 1.520" Material: 5052-H32/H34 sheet (QQ-A-250/8) 0.063" thick (M5052H32S.063) (Cut 1 stack of 8 per (4) K10017) Identify as D3178-1 Batch: M157628	EP	05/08/26	16
3	MV	Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2") Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) (M6061T6B1.500x02.500) (Cut 16 blanks per (4) K10017) Identify as D3175-1 Batch: M16747 (Note: (2) D3175-1 are required per D3175-041 assembly)	EP	05/08/26	32
4	MV	Cut blanks: 2.125" x 1.250" Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) (Cut 8 blanks per (4) K10017) Identify as D3175-3 Batch: M17807	EP	05/11/13	16
5	MV	Machine D3178-1 as per Folio FA296 and Dwg D3178	EP	05/11/14	16
6	QC2	Inspect parts as they come off the CNC machine	EP	05/11/14	16
7	QC8	Second inspection	JL	05.11.14	16
8	MV	Machine D3175-1 as per Folio FA293 and Dwg D3175	SP	05.11.15	43
9	QC2	Inspect parts as they come off the CNC machine	SP	05.11.15	43
10	MV	Deburr and Tumble	SP	05.11.15	43
11	QC8	Second inspection	TL	05.11.16	43
12	MV	Machine D3175-3 as per Folio FA294 and Dwg D3175	SP	05.11.16	16
13	QC2	Inspect parts as they come off the CNC machine	SP	05.11.16	16
14	MV	Deburr and Tumble	SP	05.11.16	16
15	QC8	Second inspection	BL	05.11.16	16
16	GA	C'sink D3178-1 holes as per Dwg D3178	SA	05/11/17	16
17	GA	Deburr stack of D3178-1	SA	05/11/17	16
18	QC5	Inspect C'sink	Z	05.11.17	16
19	FP	Chemical Conversion Coat D3178-1, D3175-1 & D3175-3 per QSI 005 4.1	SAP	05/11/19	16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/11/14	# 8	(1) one part scrap D375-1 origin was off. by 0.040" to small.	AB 05/11/14	Scrap, destroy and Replace. fix origin so it never happens again	EN 05/11/14	J	AB 05/11/14	J

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 05-12-2014

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	22409
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	1

Page 2 of 2

Step	Location	Procedure	By	Date	Qty
20	QC3	Inspect Conversion Coat	SB	05/11/22	8
21	GA	Assemble D3178-041 as per Dwg D3178 Pick: Qty Part Number Description Batch 16 MS20426AD3-4 Rivet M15786 8 MS21059L3 Nut Plate M12240 (12) M6214602	SB	05/11/22	8
22	QC5	Identify as D3178-041	2	05-11-28	8
23	GA	Assemble D3175-041 as per Dwg D3175 Pick: Qty Part Number Description Batch 4 AN3-7A Bolt M5288 8 AN960JD10L Washer M18235 4 MS21042L3 Nut (or -3) M17652 Identify as D3175-041	SB	05/11/22	8
24	QC5	Inspect D3175-041 Assembly	2	05-11-28	8
25	FP	Powder Coat D3175-041 Only Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	FC	05 12 07	8
26	QC3	Inspect Powder Coat	M	03 12 07	8
27	PK	Identify and Stock as K10017. Note: (1) Kit consists of (2) D3175-041 and (2) D3178-041. Part Number Description Qty D3175-041 Mounting Lug 16 D3178-041 Nut Plate 16 1P+1P=2P	16	05/11/22	16
28	AC	Parts to stock and Prorate cost to parts per Step 27. Cost / part	✓	05/12/06	16
29	DC	Close W/O Inspect Level 21	19	05/12/06	16

P10

CJ

Rev	Date	Change	Revised By	Approved
A	03.01.28	New issue	KJ/RF	
B	03.02.28	Modify Step 1,2,3,4,21,23	KJ/RF	RF

RELEASED
03.02.04 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05/11/28	23	11x D 3175-1 brackets left over. Identify and stock Loc: 402	CL	05/11/28	11	U 05/11/28	Z 05/11/28	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA:

Date: 05/12/20

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

D3065-5DART AEROSPACE LTD	Work Order:	22469
Description: Bracket	Part Number:	D3175-1
Inspection Dwg: D3175	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>SP</i>	Audited by:	<i>QinL</i>	Prototype Approval:	N/A
Date:	05/11/14	Date:	05/11/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/o K10017	KJ/RF	AT

RELEASED

PF 04.04.26

D3065-5DART AEROSPACE LTD	Work Order:	22409
Description: Spacer	Part Number:	D3175-3
Inspection Dwg: D3175	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>SG</u>	Prototype Approval:	
Date:	<u>05.11.16</u>	Date:	<u>05.11.16</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue (P/O K10017)	KJ/RF	PF

RELEASED

Rf 04.04.26

DART AEROSPACE LTD	Work Order:	22409
Description: Nut Plate	Part Number:	D3178-1
Inspection Dwg: D3178	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>CS</i>	Audited by:	<i>MJ</i>	Prototype Approval:	N/A
Date:	<i>05/11/14</i>	Date:	<i>05/11/14</i>	Date:	N/A

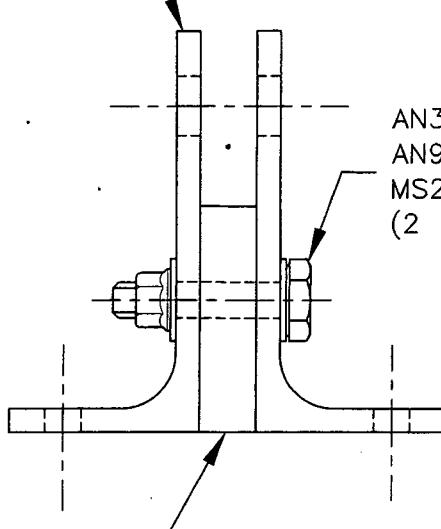
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	Plo K10017	KJ/RF

RELEASED

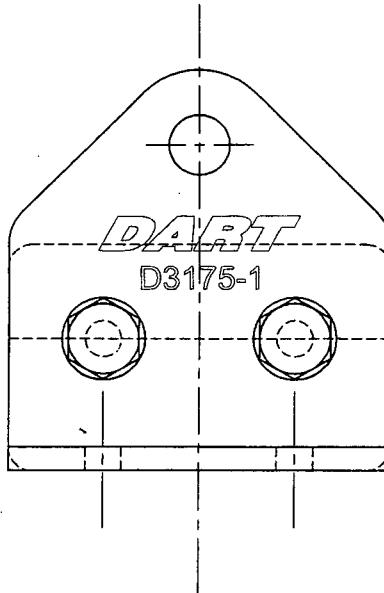
11F 04.04.26

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO.	REV. A
		D3175	SHEET 1 OF 2
DATE	TITLE	SCALE	
02.12.03	MOUNTING LUG	1:1	
A	02.12.03	NEW ISSUE	

D3175-1
(2 PLACES)

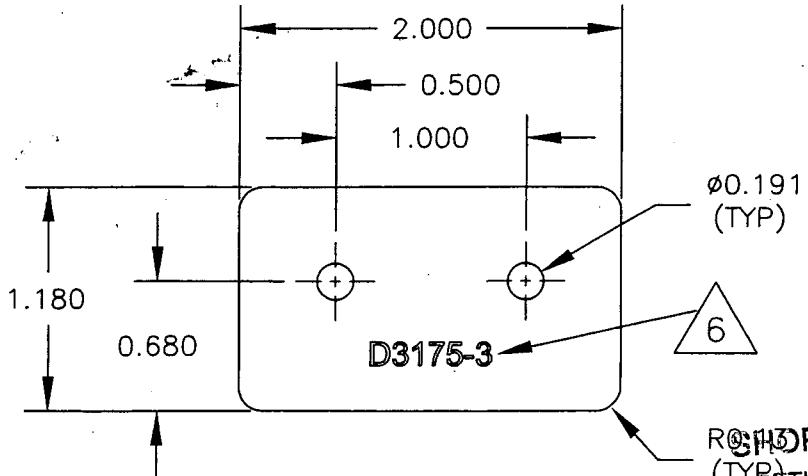
AN3-7A BOLT (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)



D3175-3

D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3

RELEASED
02-12-03 *#*
**D3175-3 SPACER**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

ROTATED COPY
(TYP)
RETURN TO
ENGINEERING

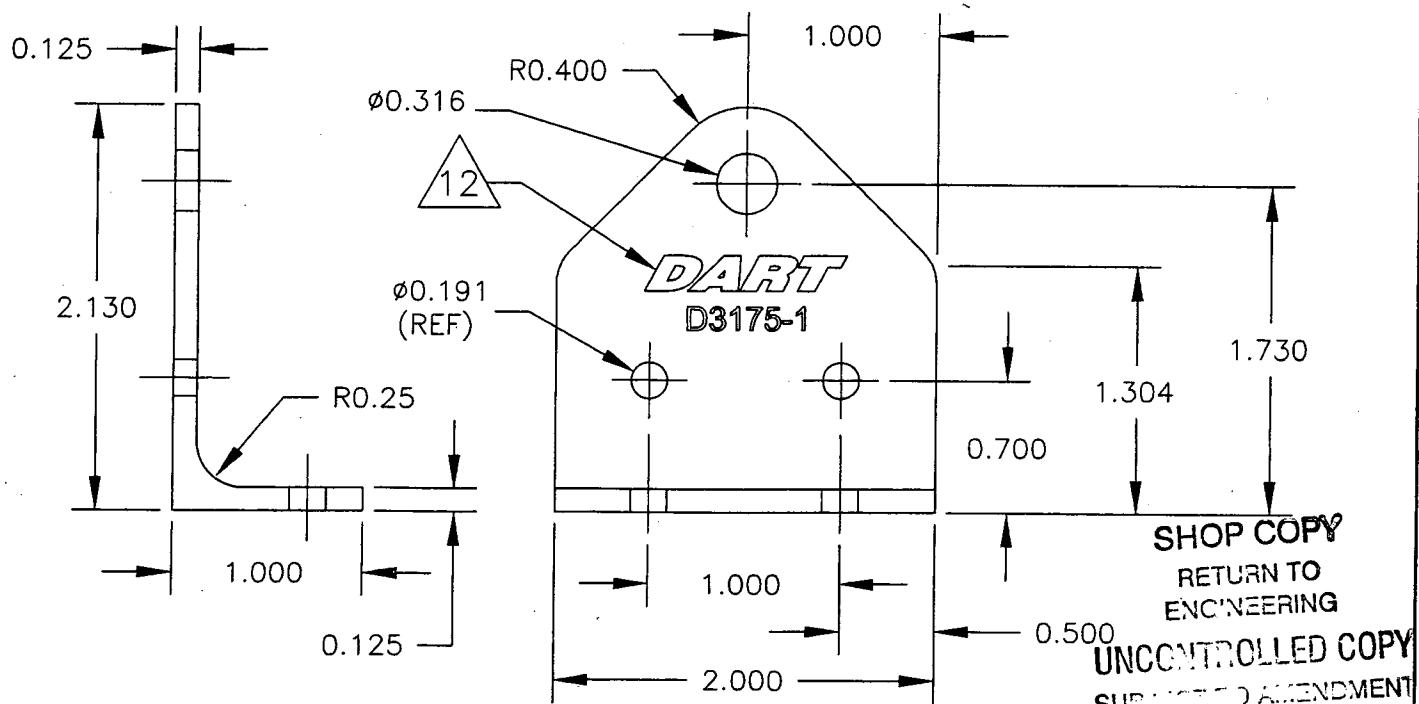
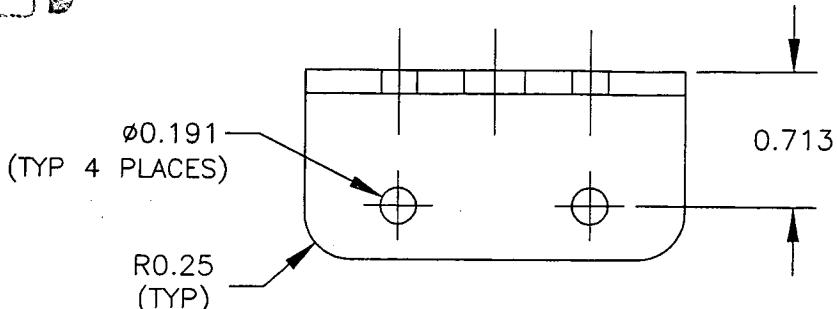
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22409
Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3175
DATE 02.12.03	TITLE MOUNTING LUG*	SCALE 1:1

RELEASED
02.12.03**D3175-1 BRACKET**

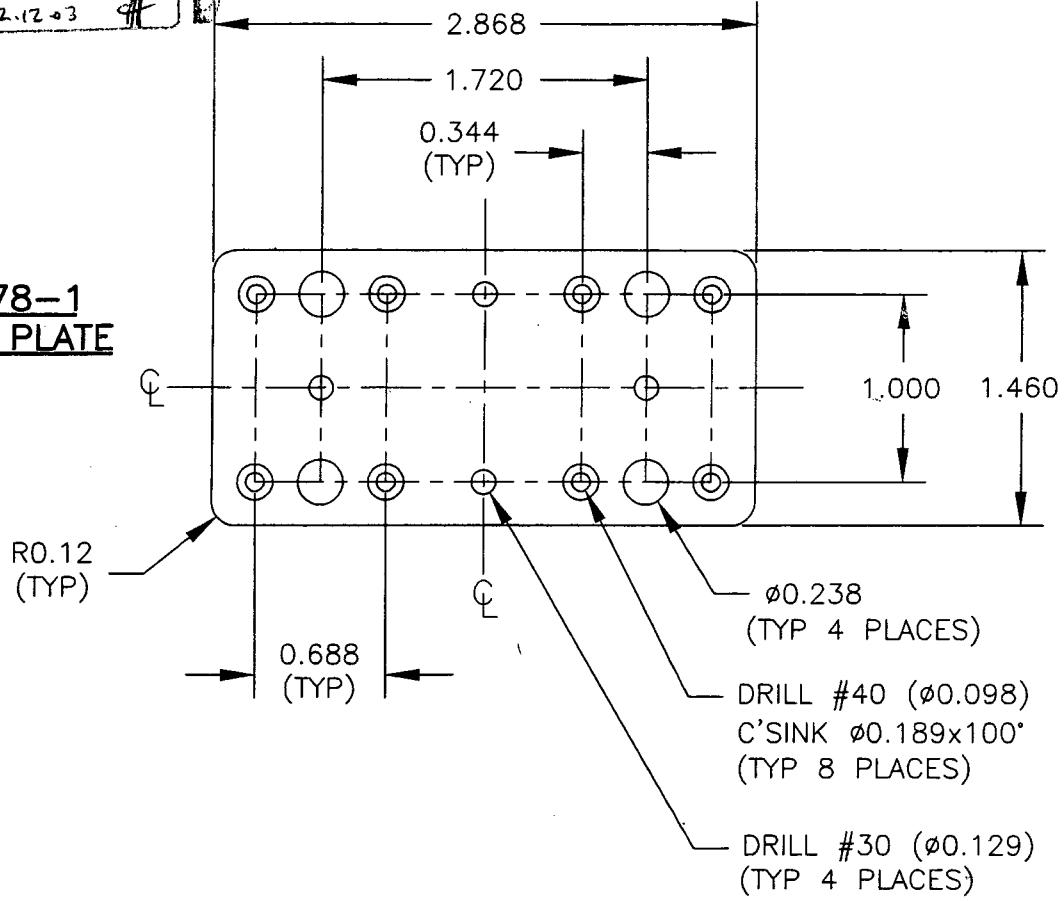
- 7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
 - 8) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 11) ALL DIMENSIONS ARE IN INCHES
 - 12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX
- 22409*

DART

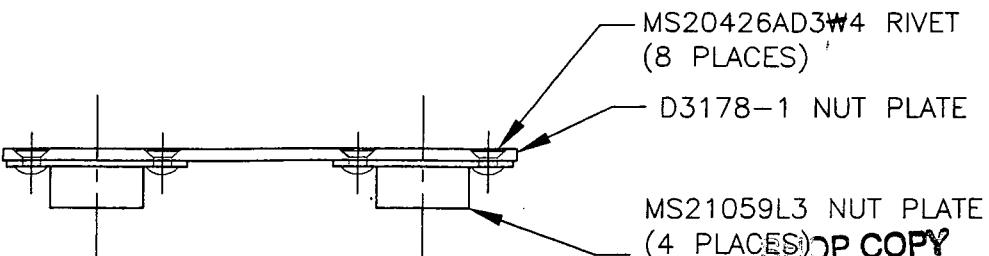
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3178
DATE		REV. A SHEET 1 OF 1
02.12.03		SCALE 1:1
A	02.12.03	NEW ISSUE

RELEASED
02.12.03

D3178-1
NUT PLATE



D3178-041
NUT PLATE



NOTES D3178-1 NUT PLATE:

- PART IS SYMMETRIC ABOUT CENTERLINES
- MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)
(REF DART SPEC. M5052H32S.063)
- BREAK ALL SHARP EDGES 0.005-0.010
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22409

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
HawkesburyFeb 14, 2005
07:34 am

Work Order No : 0022409
 Project Name : K10017
 Project For : WK515
 Work Order Type : Main
 Main WO Number :
 House Part Number : *K10017
 Description : Mtg Lug/Nut Plate Kit
 Manufactured : Yes
 Amount Req'd : 1
 Amount Done : 0
 Start Date : 02-11-05
 Est Finish Date : 02-24-05
 Act Finish Date :
 Drawings Reqd : No
 'Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
HawkesburyNov 08, 2005
10:12 am

Work Order No : 0022409
 Project Name : K10017
 Project For : WK515
 Work Order Type : Main
 Main WO Number :
 House Part Number : *K10017
 Description : Mtg Lug/Nut Plate Kit
 Manufactured : Yes
 Amount Req'd : 1
 Amount Done : 0
 Start Date : 02-11-05
 Est Finish Date : 02-24-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
	=====	=====	=====		
Burden :	0.00	0.00	0.00		
	=====	=====	=====		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

Date: Tuesday, 11/22/2005 7:51:17 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG/NUT PLATE KIT		
Job Number	: 22409			Part Number	: K10017		
Estimate Number	: 10830			Drawing Number	: N/A		
P.O. Number	:			Project Number	:		
This Issue	: 11/22/2005	S.O. No.	:	Drawing Revision	: N/A		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 11/29/2005		
Previous Run	: 22409			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est: B 03.02.28 Modify Step 1,2,3,4,21,23			KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	22409A	MOUNTING LUG	
Comment: Sub-Component MOUNTING LUG			
2.0	22409B	NUT PLATE ASSEMBLY	
Comment: Sub-Component NUT PLATE ASSEMBLY			
3.0	22409C	MOUNTING LUG ASSEMBLY	
Comment: Sub-Component MOUNTING LUG ASSEMBLY			
4.0	D3175041	Mounting Lug	
5.0	D3178041	Nut Plate	
6.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
Comment: INSPECT 100% KITS FOR COMPLETENESS			
7.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____			
8.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL Inspection Level 21			
Job Completion			

Date: Tuesday, 11/22/2005 7:52:24 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	: 22409A			Part Number	: D31753		
Estimate Number	: 10817			Drawing Number	: D3175 REV. A		
P.O. Number	:			Project Number	:		
This Issue	: 11/22/2005	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 11/29/2005 Qty: 2 Um: Each		
Previous Run	: 22409B						
Written By	:						
Checked & Approved By	:						
Comment	: Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25"
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 2.125" x 1.250"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA294 and Dwg D3175 Deburr and Tumble Identify as D3175-3		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

Date: Tuesday, 11/22/2005 7:52:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 22409A

Part Number: D31753

Job Number:



Seq. #:	Machine Or Operation:	Description :
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<p>Comment: INSPECT CHEMICAL CONVERSION COAT</p>		
8.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p>		
9.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL Inspection Level 21</p>		

Job Completion



Date: Tuesday, 11/22/2005 7:52:29 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: NUT PLATE ASSEMBLY		
Job Number	: 22409B			Part Number	: D3178041		
Estimate Number	: 10812			Drawing Number	: D3178 REV. A		
P.O. Number	:			Project Number	:		
This Issue	: 11/22/2005	S.O. No.	:	Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: //	Type	: SMALL /MED FAB	Due Date	: 11/29/2005	Qty:	2
Previous Run	: 22409C			Um:	Each		
Written By	:			Comment	: Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blanks: 3.00" x 1.520"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA296 and Dwg D3178 Identify as D3178-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- C'sink D3178-1 holes as per Dwg D3178 2- Deburr		

Date: Tuesday, 11/22/2005 7:52:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 22409B

Part Number: D3178041

Job Number:



Seq. #:	Machine Or Operation:	Description :
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT CHEMICAL CONVERSION COAT		
10.0	MS20426AD34	RIVET
11.0	MS21059L3	Nut Plate
12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3178		
13.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
14.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
15.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Inspection Level 21		
Job Completion		

Date: Tuesday, 11/22/2005 7:52:38 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG ASSEMBLY		
Job Number	: 22409C			Part Number	: D3175041		
Estimate Number	: 10816			Drawing Number	: D3175 REV. A		
P.O. Number	:			Project Number	:		
This Issue	: 11/22/2005	S.O. No.	:	Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 11/29/2005	Qty:	2
Previous Run	: 22409D			Um:	Each		
Written By	:			Comment	: Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X02500	6061-T6 Bar 1.5" x 2.5"
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2")		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA293 and Dwg D3175 Deburr and Tumble Identify as D3175-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

Date: Tuesday, 11/22/2005 7:52:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG ASSEMBLY

Job Number: 22409C

Part Number: D3175041

Job Number:



Seq. #:	Machine Or Operation:	Description :
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<p>Comment: INSPECT CHEMICAL CONVERSION COAT</p>		
8.0	D31751	Bracket
9.0	D31753	Spacer
10.0	AN37A	Bolt
11.0	AN960JD10L	Washer
12.0	MS21042L3	Nut
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3175</p>		
14.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP</p>		
15.0	POWDER COATING	POWDER COATING
<p>Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3</p>		
16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<p>Comment: INSPECT POWDER COAT</p>		
17.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p>		
18.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL Inspection Level 21</p>		
Job Completion		